














Date: Tuesday, 05/09/2006 10:33:48 AM  
User: Linda Lacelle

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LEVER
Job Number	: 28386		
Estimate Number	: 10585		
P.O. Number	: <i>N/A</i>	Part Number	: D2160
This Issue	: 05/09/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2160 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 01/09/2006 Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 21845	Material	: <i>N/A</i>
Written By	: _____	Due Date	: 15/09/2006 Qty: 10 Um: Each
Checked & Approved By	: _____		
Comment	: Est. C 04.11.04 Reformat KJ/RF		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304S14GA	304SS .080	
			
Comment: Qty.: 0.0167 sf(s)/Unit Total : 0.1670 sf(s) 304SS .080 <i>M10/873</i> <i>11/08 09 06</i>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET <i>M10 06 09 06</i> (10)			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>M10 06 09 06</i> (10)			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <i>06 09 06</i> (10)			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary <i>SAN</i> <i>06 09 10</i> (10)			
6.0	BRAKE NC	NC BRAKE	
			
Comment: NC BRAKE Form as per Dwg D3245 Identify as D2160 <i>SB</i> <i>06/01/08</i> 10			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEVER

Job Number: 28386

Part Number: D2160

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

NA 06/14/08 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St027

LB 06/11/09 (10)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/11/09 (10)

Job Completion



c 206111109

Date: Friday, 9/1/2006 12:06:44 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : LEVER
<b>Job Number</b> : 28386	
<b>Estimate Number</b> : 10585	
<b>P.O. Number</b> :	<b>Part Number</b> : D2160
<b>This Issue</b> : 9/1/2006 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2160 REV <i>X B 4w/06-09-06</i>
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : <i>KB</i>
<b>Previous Run</b> : 21845	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 9/15/2006 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est. C 04/11.04 Reformat KJ/RF	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0

PG

PURCHASING

**Comment:** PURCHASING

Issue P/O: \_\_\_\_\_

Email or Ship DXF file to vendor

Laser Cut flat pattern as per Dwg D2160

Material release note is required

*0166*  
*28386*  
*M3015146A*  
*W. H. H. H.*

*MM B0906*

2.0

D2160F

Lever



**Comment:** Qty.: 1.0000 Each(s)/Unit      Total : 10.0000 Each(s)  
 Lever

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

5.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Deburr if necessary

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 9/1/2006 12:06:45 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEVER

Job Number: 28386

Part Number: D2160

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3245

Identify as D2160

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

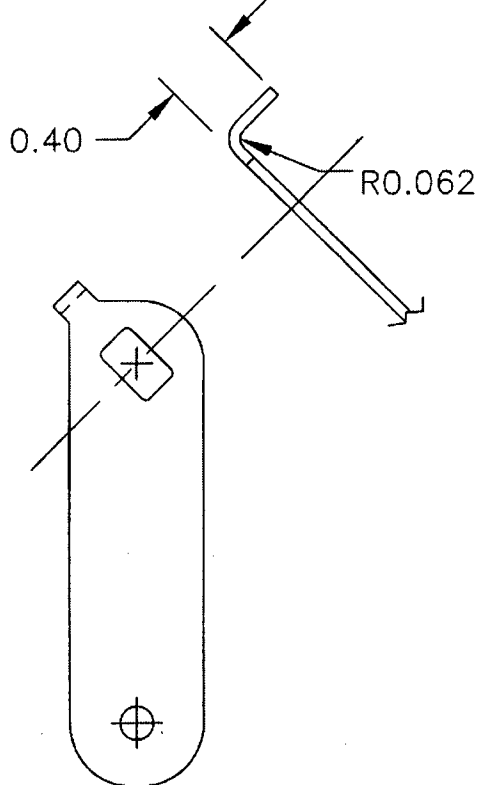
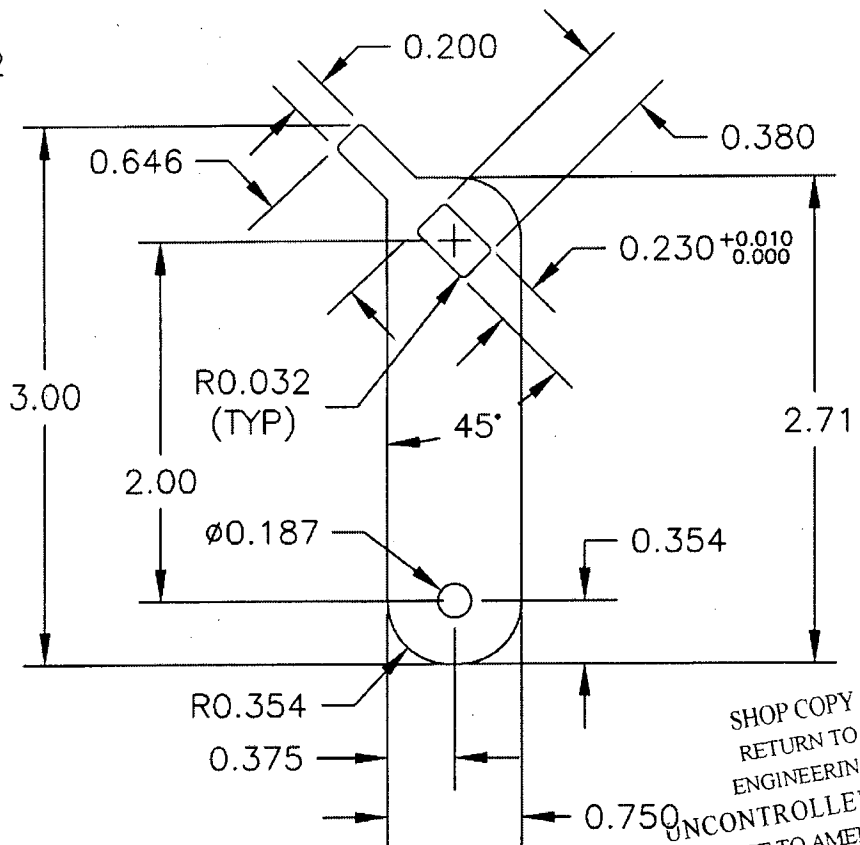
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2160	REV. B SHEET 1 OF 1
DATE 05.01.25	TITLE LEVER		SCALE 1:1
A	93.04.04	NEW ISSUE	
B	05.01.25	ADDED FLAT PATTERN; REMOVED Ø0.106	

**RELEASED**  
05.02.02**BEND DETAIL****FLAT PATTERN**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28386

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.075 (14 GAUGE) THICK (REF. DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ALL DIMENSIONS ARE INCHES

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